

Friday, 5/25/2007 8:24:06 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKIDTUBE ASSEMBLY
Job Number	: 32616		
Estimate Number	: 10022		
P.O. Number	: N/A	Part Number	: D205634011
This Issue	: 5/25/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 32615	Material	: N/A
Written By	:	Due Date	: 6/30/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: Est Rev: 02.08.28 Removed QC5 from Step 5 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG004

KJ 07-06-05 (1)

2.0	32616A	SKID TUBE ASSEMBLY
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Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 032616 A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit

1 D205-634-041 Skidtube Assembly(ref)

B31129

032616A

EJ 07/08/01 (2)

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

7/18/1 SP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:24:07 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 32616

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: *REV: J*

REV: J *07/08/01* *SP*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Jul 07-08-01

B32-616-A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:24:40 AM
 User: Kim Johnston

Process Sheet

26

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY
 Job Number : 32616A
 Estimate Number : 10023
 P.O. Number : N/A Part Number : D205634041
 This Issue : 5/25/2007 S.O. No. : N/A Drawing Number : D2580 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C
 Previous Run : 32615A Material : N/A
 Due Date : 6/30/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 Est Rev: O 06.02.28 Added paperwork EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001

N/A

2.0 D25001190 Ext'n -1' Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B 29602

JD 7-6-14

3.0 D2596 205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	B 32218

JD 7-6-14

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Inspect mat'l D2500-1-190 for damage
- 2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends
- 3-Acid etch and Alodine tube per QSI 005 4.1
- 4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

JD 7-6-13

JD 7-6-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Friday, 5/25/2007 8:24:40 AM
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Process Sheet

Customer: CU-DAR001. Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32616A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 *m103561*

Sikaflex expire date: *7-10-1*

Start Time: *3:30* Date: *7-6-14*

Fin Time: *8:30* Date: *7-6-29*

5076-14

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL 7-6-29

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

K 7-7-10

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Pms go through
all the holes
So 070710 (X1)*

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2576-3 Step

BE 070710 13

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32616A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

20

D2579

Spacers

D32026 BE 07-07-13

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

BE 07-07-13

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

M104721

BE 07-07-13

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

M104721

BE 07-07-13

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

7-7-12

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

7-7-16

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/16

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/02/17 (21)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

BL

07-07-25

0.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Job Number: 32616A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

POWDER COATING

POWDER COATING



M105068

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR/FL 07-07-26

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



①

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/07/26

16.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-1

Wearplate

B31212 M-L

17.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-3

Wearplate

B30551 M-L

18.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D2577-5

Wearplate

B31254 M-L

19.0

ALS71032130

Insert



* ①

Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

44

ALS7-1032-130

Inserts

M103495

M-L 07/07/26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32616A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 4 AN960JD10L Washer

M103641 m-l

21.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number Description Batch
44 AN3-4A Bolt

M104817 m-l

22.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

plug

Batch: B 32651

m-l

23.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

o-ring

Batch: B 27168

m-l

24.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B 27488

m-l

25.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M100188

m-l 07/07/27 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 21/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:24:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32616A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch:

M103641

m-h

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

M104989

Sikaflex expire date: 08-01

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

M104989

Sikaflex expire date: 08-01

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

M104942

Batch:

0707220

28.0

QC5

INSPECT WORK TO CURRENT STEP



Er 07/07/30



At plug in tube

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

0732616

FINAL INSPECTION/W/O RELEASE

30.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



4-11

070815

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED
98/09/17 DS

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576 - 3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

00.08.28
UP 00.08.28

EFFECTIVE DEOS
98/12/14
DEO 9124
DED 9183

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32616A

Diagram of a circular cross-section of a pipe with four vertical stiffeners. The stiffeners are spaced 3.500 units apart. The distance from the centerline to the outer edge of the stiffeners is 1.750 units.

Diagram illustrating the grinding locations on a propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- GRIND FLUSH
- GRIND FLUSH

UNC
SUB

0.40

D2575 CAP

AN96QJD10L WASHER (1)
(2 PLACES)

AN3-4A BOLT (1)

DRILL PRIOR TO D2575 CAP
INSTALLATION (2 PLACES)

SEAL WITH
SIKAFLEX-241

D2579 SPACER

WEB (REF)

130 (REF)
14 PLACES

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

Elevation view of the bridge deck showing reinforcement details. The diagram includes the following dimensions and annotations:

- Top Left:** A horizontal dimension of 37.50 from the left edge to the centerline. Below it, two triangles labeled "3" and "7" are shown, with the text "DISTANCE TO AFT END OF D2596 WEB" above them.
- Reinforcement Bars:** Two main reinforcement bars are shown as circles. The first bar has a diameter of 8.750. The second bar has a diameter of 17.375. The distance between the centers of these two bars is 26.000.
- Dimensions:**
 - A horizontal dimension of 38.0 from the left edge to the centerline.
 - A horizontal dimension of 34.188 from the centerline to the right edge.
 - A horizontal dimension of 91.500 from the left edge to the right edge.
 - A horizontal dimension of 57.313 (REF) from the centerline to the right edge, labeled "7 EQUAL SPACES B.188 PITCH".
 - A horizontal dimension of 190.0 at the bottom, labeled "(D2500-1)".
- Annotations:**
 - "REFER TO DETAIL A" points to both reinforcement bars.
 - "#0.508 (TYP.) (40 PLACES)" indicates the spacing of the reinforcement bars.
 - "REFER TO DETAIL A" points to the right end of the deck.

Diagram illustrating the cross-section of a road with a shoulder and a hole. The diagram shows a 1.4m wide shoulder, a 1.0m distance between hole and tangent point, a 13.4m distance between hole and tangent point, a 20.0m distance between hole and tangent point, a 32.0m distance between hole and tangent point, and a 11.5m height.

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 D P P P P P P P

REFER TO DETAIL C

D2577-3

8

D2577-5


D2577-1

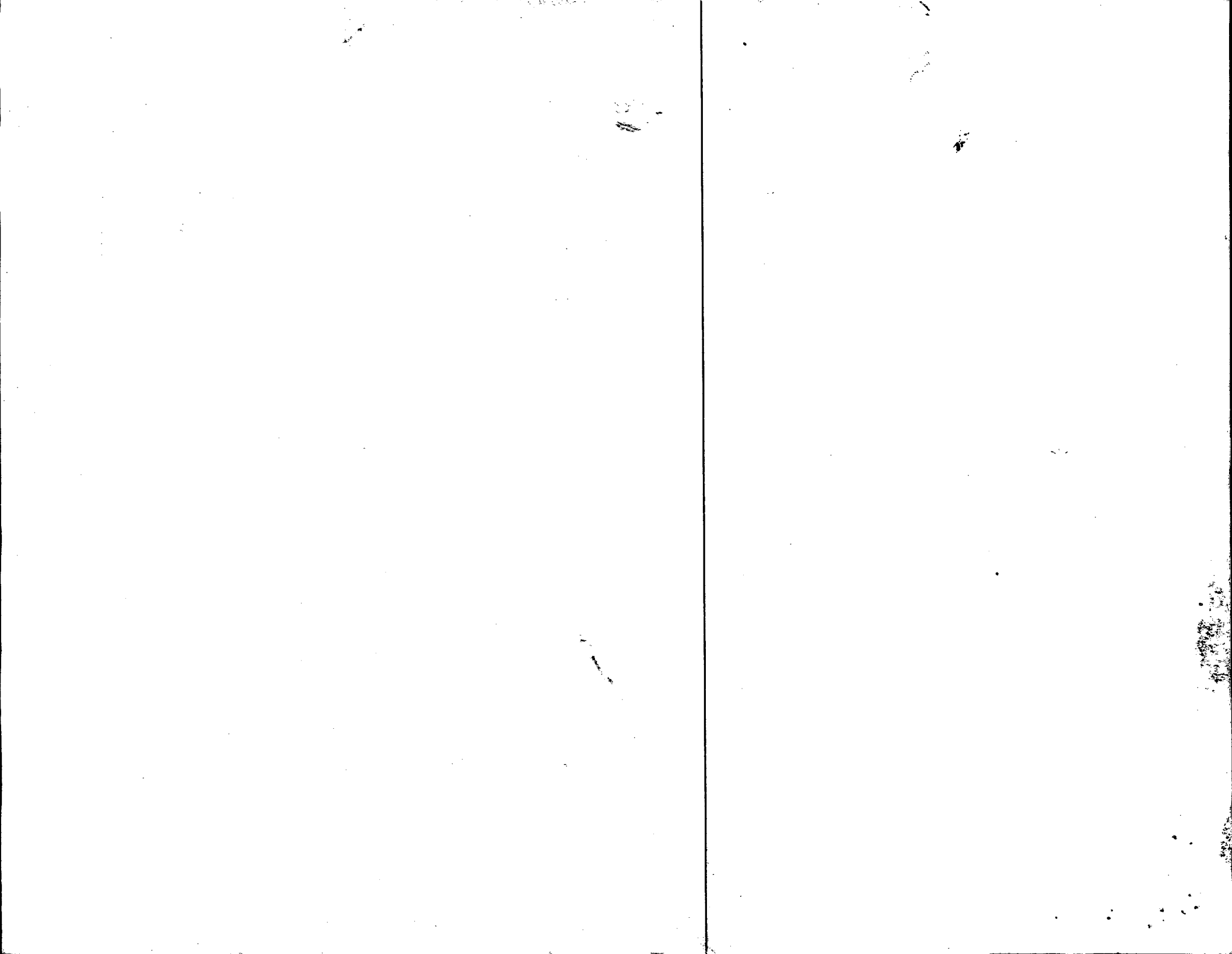
AN3-4A BOLT (1)
AN960JD10L WASHER (1)
(44 PLACES)

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>
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PART

RELEASED
98/09/17 DS

DESIGN <i>DAB</i>	DRAWN BY <i>CP</i>	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>DAB</i>	APPROVED <i>JS</i>	
DATE 98.08.26	DRAWING NO. D2580	REV. C SHEET 2 OF 2
	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24



NO. 116

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number A205634041/B32617A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/07/16 Qualifier Sam A. Arenal

Date: Tuesday, 21/08/2007 10:31:57 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : REMOVE K10003
Job Number : 34119	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : D205634041
This Issue : 21/08/2007 S.O. No. : N/A	Drawing Number : D205634011 TO 041
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 32546	Material : N/A
Written By : _____	Due Date : 20/08/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : _____	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REMOVE FROM STK: 32616
 X D205-634-011 B

7/8/21 SP

REMOVE K10003 KITS AND RESTOCK
 RECORD B/N'S:

31129

2.0	D205634011	Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Replacement Skidtube

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

2 chg 001 for -041 2

REPACKAGE USING SAME B/N
 NEW LABELS REQ'D -041'S

DART			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	D205-634-011	CHG	CHG004
DESC	Skidtube	STC	SH96-88
LOT	B32616	STC	SR00563NY
MODEL	Bell 205/210/212/214/412	STC	

US PATENT # 5735464

TEL.: 1-613-632-3336
 FAX: 1-613-632-4443